

MERIT™ JG-Ni1**CONFORMANCE**

- AWS 5.28: ER80S-Ni1
- EN ISO 636-A: W 42 6 W3Ni1

APPROVALS

- ISO 9001 Quality Management System
- JIS Certificate Of Compliance

APPLICATIONS

- Offshore
- Pipeline
- Process Piping

WELDING POSITIONS**PRODUCT FEATURES**

- Low nickel alloy TIG rod
- Use with 100% Argon shielding gas
- Designed for root pass welding of low Ni alloy steels/fine grained steels/550MPa tensile strength steels (such as Q345E/S355/EH36)
- High quality rod from clean and consistent raw material
- Excellent weld puddle control
- Outstanding impact values at low temperature (-60°C)
- Embossed on each end for easy alloy identification

DIAMETERS AVAILABLE

- 1.6mm
- 2.0mm
- 2.4mm
- 3.2mm
- 4.0mm

STANDARD PACKAGING

- Plastic Tube: 5KG, 10KG

* Please contact your local Lincoln Electric sales office for alternative types of packaging.

MERIT™ JG-Ni1**CHEMICAL COMPOSITION OF SOLID WIRE(Wt-%)**

MERIT™ JG-Ni1	C	Mn	Si	S	P	Ni
AWS Requirement	0.12 max.	1.25 max.	0.40-0.80	0.025 max.	0.025 max.	0.80-1.10
Typical Value	0.089	1.14	0.58	0.004	0.008	1.04

CHEMICAL COMPOSITION OF WELD DEPOSIT(Wt-%), TYPICAL

Wire/Flux	C	Mn	Si	S	P	Ni
MERIT™ JG-Ni1	0.062	1.06	0.55	0.006	0.007	0.88

MECHANICAL PROPERTIES OF ALL-WELD-METAL

MERIT™ JG-Ni1	Condition	Shielding Gas	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	CVN Impact (J) @ -60°C
AWS Requirement	As-welded	100%Ar	470 min.	550 min.	24 min.	27 min.
Typical Value	As-welded	100%Ar	480	580	29	≥300

Please choose the appropriate welding parameters according to your base metal / thickness / tungsten electrode type.

Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

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